

Work Order ID 81051-2

March-07-12 2:23:01 PM

\*81051\*

Page 1

Item ID: D2888

Revision ID:

Item Name: Lug

Start Date: 07/03/2012 Start Qty: 12.00

Required Date: 21/03/2012 Req'd Qty: 12.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M.C.J.

QC:

Date: 12/03/12 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Draw Nbr

Revision Nbr

D2888

Rev A2

100

\*100\*

Bandsaw

Jeaspa Bandsaw

Memo

Cut Blanks at 4.200" long  
\*\*\*Grain along 4.200"\*\*\*\*

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

0.00

0.00

0.00

110

\*110\*

HAAS I

HAAS CNC vertical machine #1

Memo

Machine as per Folio D2888

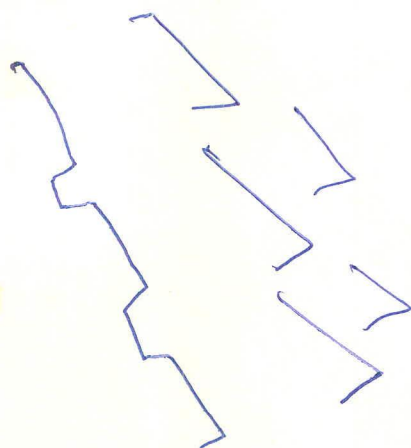
Folio Rev: AA

Dwg Rev: A2

2-Deburr

12-04-16 (F14)







# Work Order ID 81051

\*81051\*

Page 2

March-07-12 2:23:01 PM

Item ID: D2888

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 07/03/2012 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

22 12-4-17 14 4

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

B. A 12/04/18 14 4

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

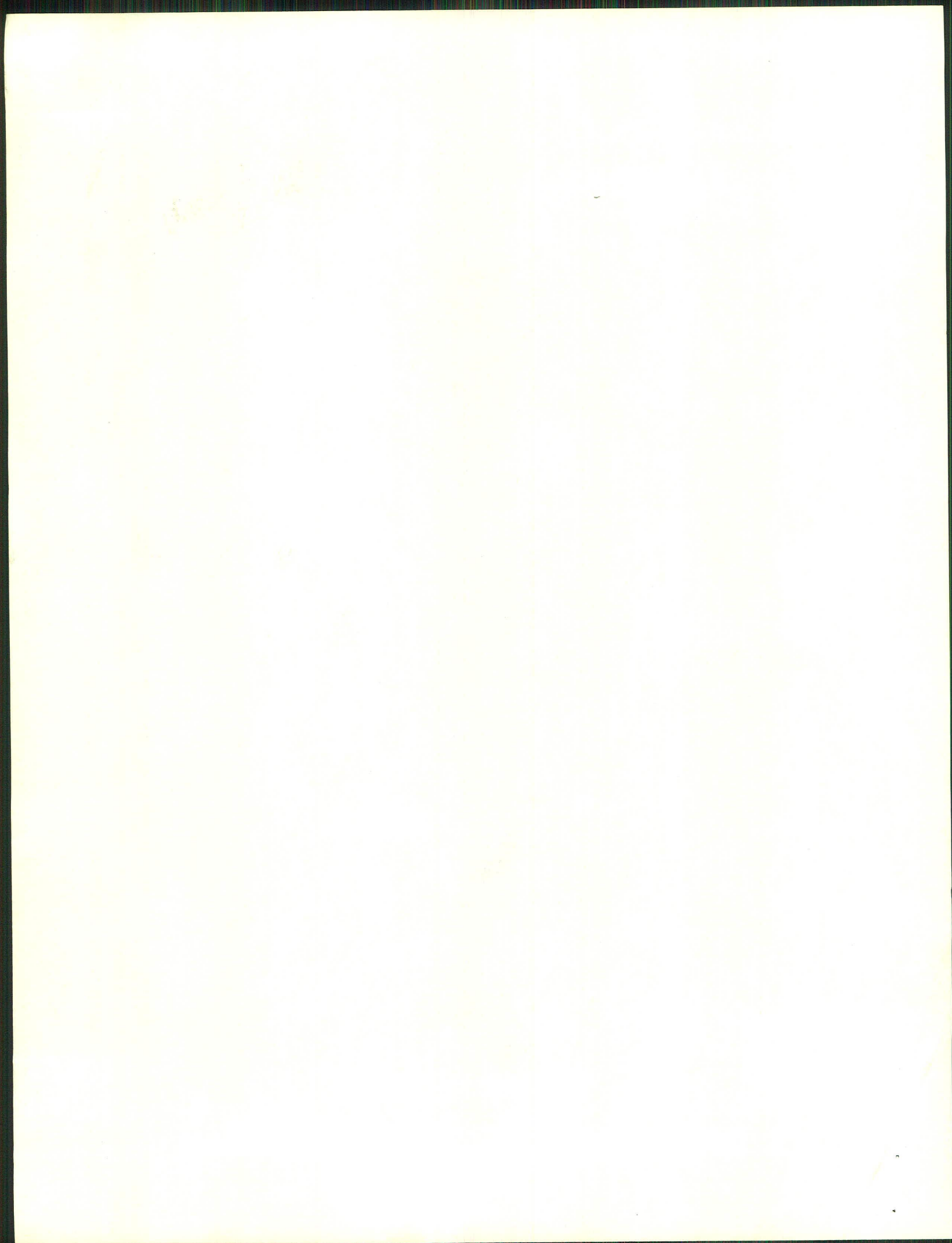
Memo

0.00

Hand Finishing

(14) 7/6 12-4-19







# Work Order ID 81051

\*81051\*

Page 3

March-07-12 2:23:01 PM

Item ID: D2888

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 07/03/2012 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*150\*

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:45

OVEN TEMPERATURE: 3200F

FINISH TIME: 8:15

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 87485

0.00

\*170\*

Packaging

Memo

0.00

Packaging

14X ✓

m/f  
12/24/24

14x

g/

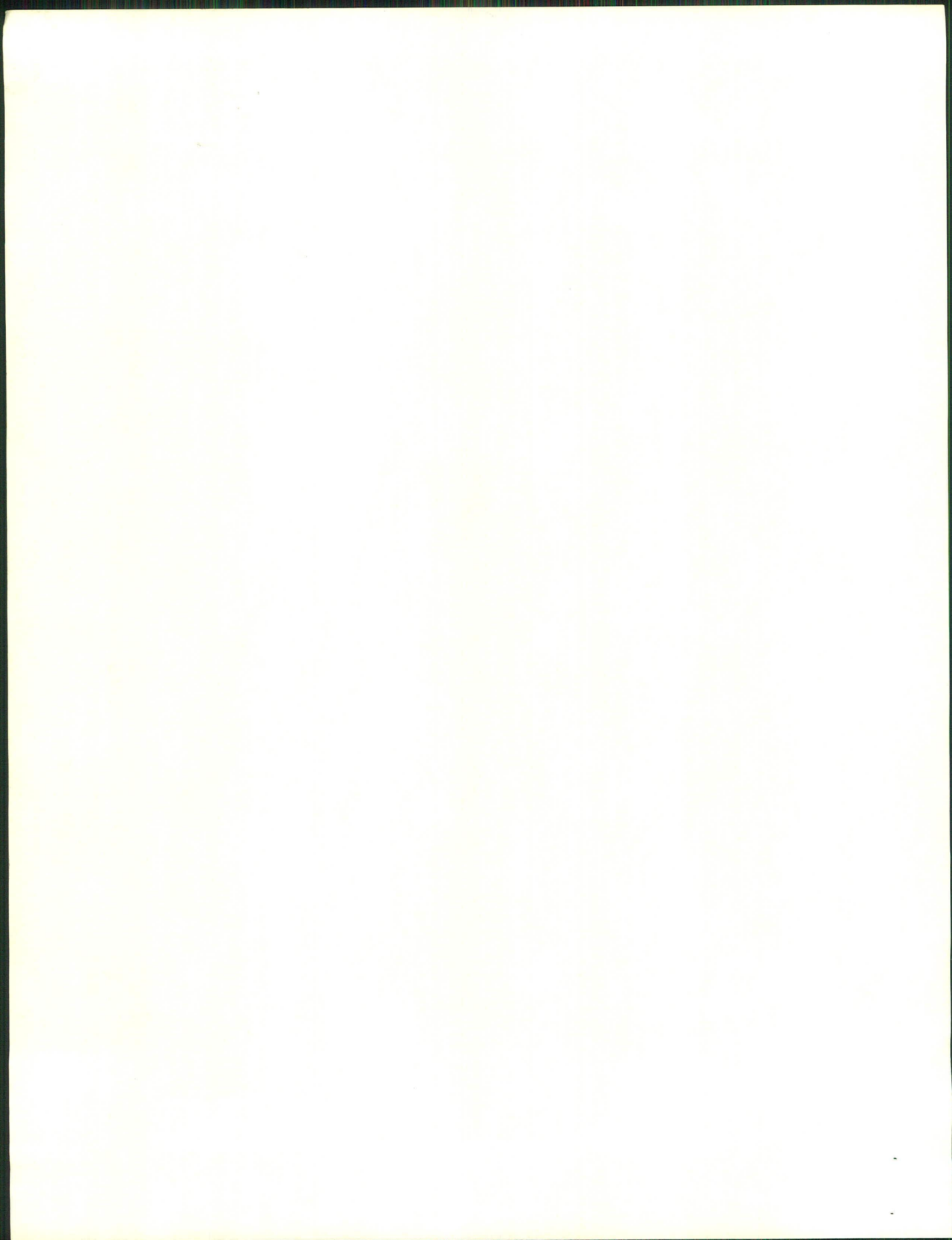
12/16/20

14x

SP  
12-04-24

m121134





# Work Order ID 81051

**\*81051\***

Page 4

March-07-12 2:23:01 PM

Item ID: D2888

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lug

Start Date: 07/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

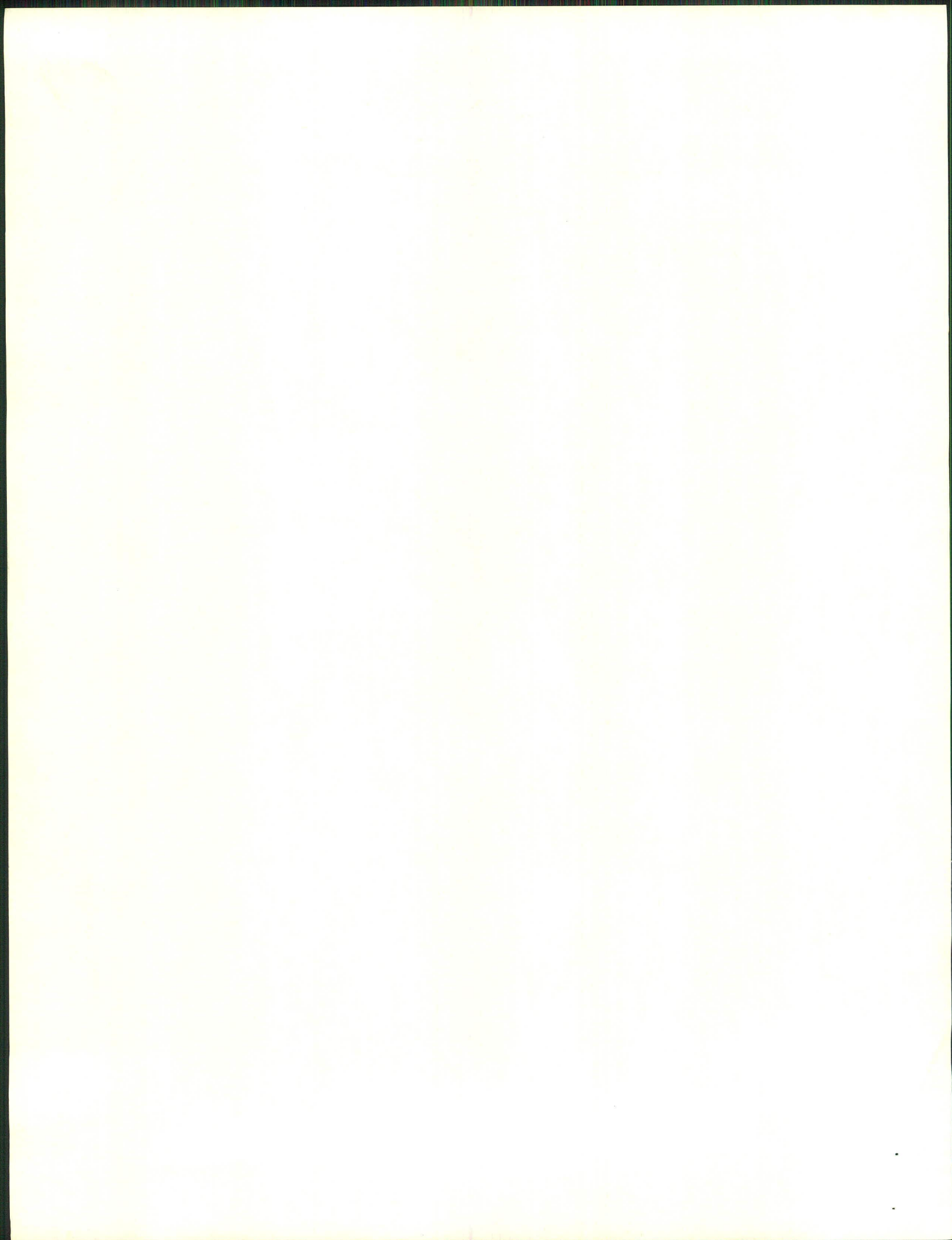
Memo

0.00

Quality Control

12/4/25 *[Signature]*  
112-04-25







# Picklist Print

March-07-12 2:23:07 PM

Page 1

Work Order ID: 81051

\*81051\*

Parent Item: D2888

\*D2888\*

Parent Item Name: Lug

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	8.0000	0.39	4.68			

\*M6061T6B2 500X03 500\*

6061-T6 Bar 2.50 x 3.50

\*\*

24 12-4-13

Location

Loc Qty

Loc Code

MAT008

8

120708 ✓

8

not in system

118021 ✓

x 12

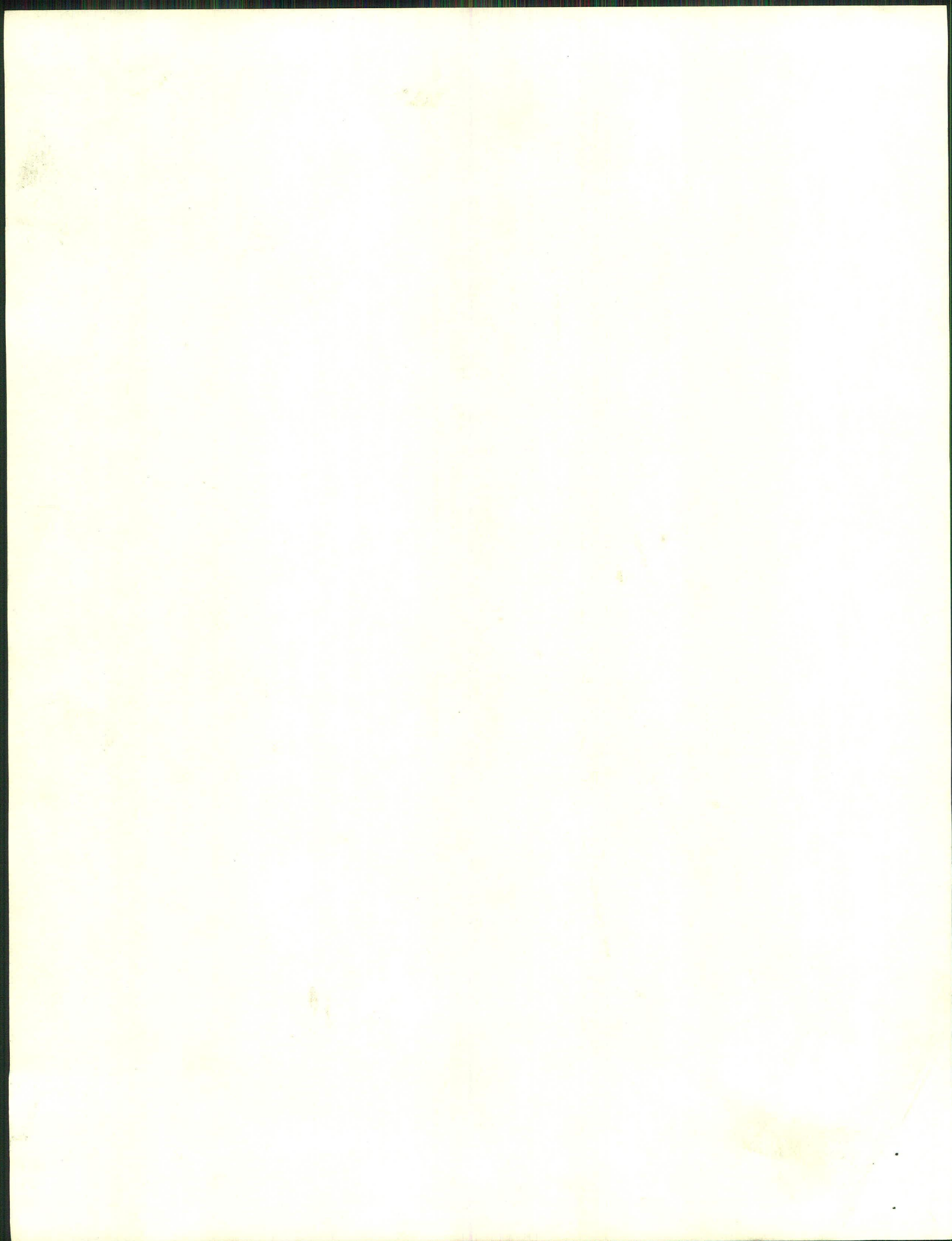
4.28'

x 4 blanks

1.416'

5.606







DART AEROSPACE LTD		Work Order:	8,051
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	.3865	✓		vern	RT - 4
Ø0.88	+/-0.030	.874	✓		"	"
0.063 x 45°	+/-0.010	.065	✓		"	"
4.06	+/-0.030	4.064	✓		"	"
Ø0.760	+0.005/-0.000	.760	✓		"	"
3.48	+/-0.030	3.484	✓		"	"
2.500	+/-0.010	2.498	✓		"	"
2.75	+/-0.030	2.75	✓		"	"
0.438	+/-0.010	.434	✓		"	"
0.080 x 45°	+/-0.010	.090	✓		"	"
1.85	+/-0.030	1.851	✓		"	"
1.000	+/-0.010	1.001	✓		"	"
0.425	+/-0.010	.425	✓		"	"
0.030 x 45°	+/-0.010	.032	✓		"	"
1.875	+/-0.010	1.881	✓		"	"
0.375	+/-0.010	.374	✓		"	"
R0.25	+/-0.030	.250	✓		sub gauge	
1.29	+/-0.030	1.288	✓		gauge	RT - 4
0.414	+/-0.010	.419	✓		"	"
3.41	+/-0.030	3.419	✓		height gauge	31006

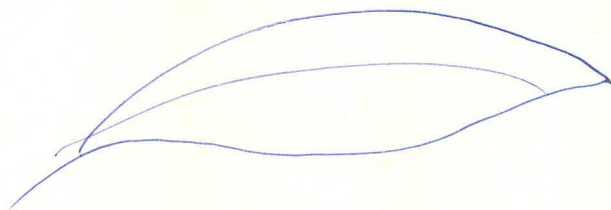
Measured by:	JE
Date:	12-04-16

Audited by:	D.A
Date:	12/04/18

Prototype Approval:	N/A
Date:	N/A

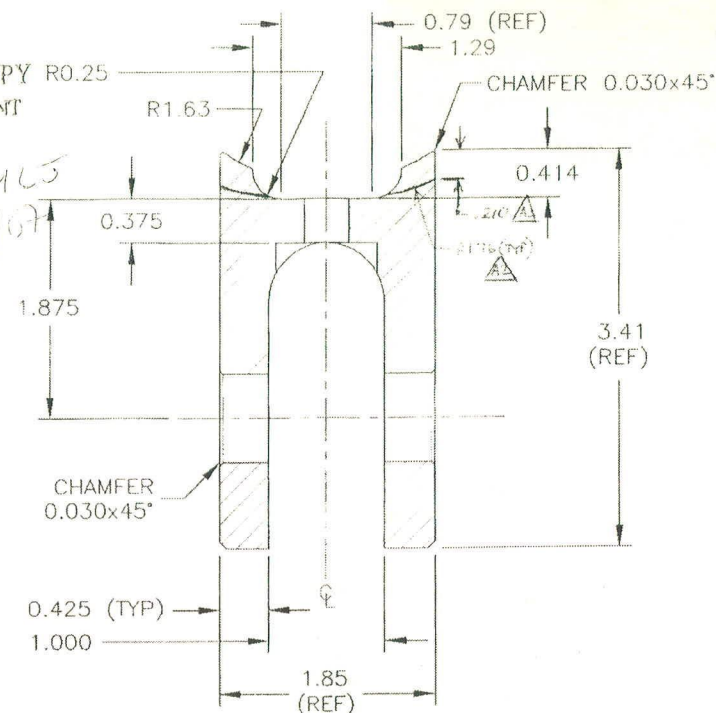
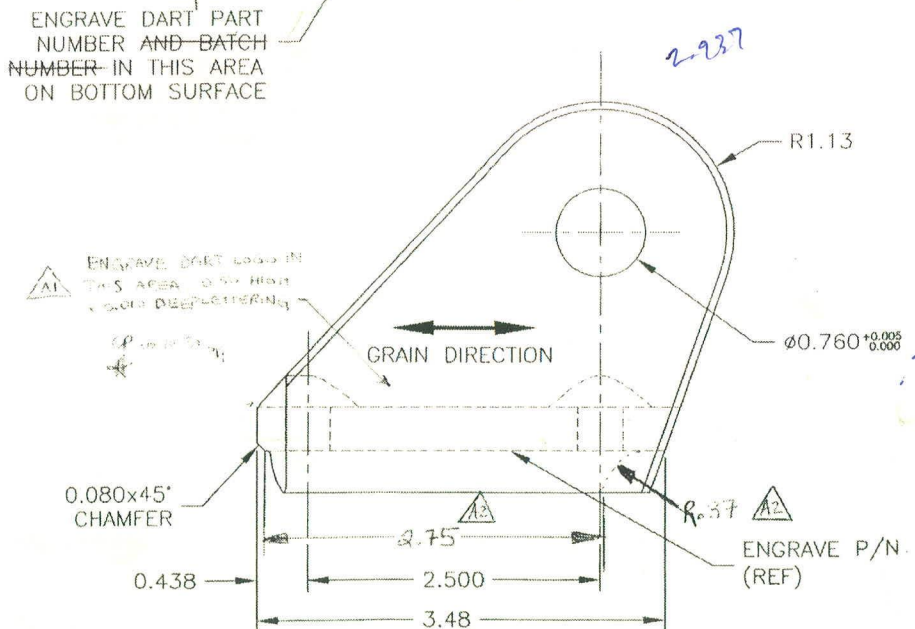
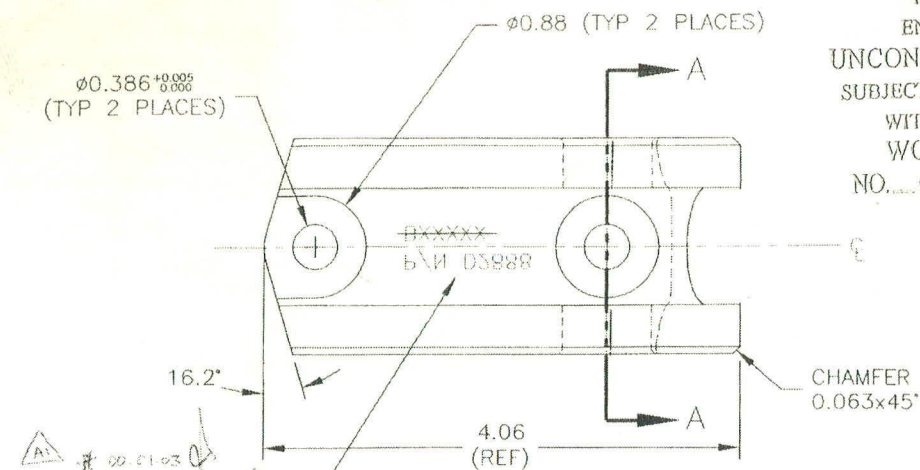
Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	







SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY R0.25  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81051 MLC  
12/03/07



SECTION A-A  
SCALE 1:1

RELEASED  
99.01.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BREAK UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	ADD Scribe Clearance
A1	00.10.01	FOR NCR 384

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY CP	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	99.06.21	TITLE LUC

212  
384  
2.596



